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D3407-041
Job Sheet 201237



Part No: D3407-041

Job Qty: 16 pcs

Part Name: Tow Ring



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/27/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 10/21/19

Type: Stock

Description:

Note: IPP Rev:A 05.10.14 New issue KJ/EC IPP Rev:B 08-09-09 revE as per dwg DD verified by:EC IPP REV:F
17.11.02 AS PER DWG REV.G DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Large Fab - Welded Assy-1	16 pcs	10/21/19	10/21/19	0.00	3.51	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		MC Jan 13/20
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
110	QC 9	16 pcs	10/21/19	10/21/19	0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	16 pcs	10/21/19	10/21/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		



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Container No: S247044



Part No: 201237

Job No: 201237

Serial No/Batch: S247044

Revision: 6
Inspector:

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					QC 5 - 9	
					QC 5 - 50	13
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
130	Powdercoat - 2 White GI(S)- B4B	16 pcs	10/21/19	0.00 0.60	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	Bl 20-06 14
					Powdercoat - 4 - B4B	
140	QC 3	16 pcs	10/21/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	JAN 1 4 2020 40 9-89
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
150	Packaging 3-1 - Stock - B4B	16 pcs	10/21/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	✓ SI 530 DAS 80 9-89
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	JAN 1 5 2020
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 -	

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					B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
160 QC 21 - SA	16 pcs	10/21/19	0.00 0.00	QC 21 - SA - 21 ✓	ST 530	
				QC 21 - SA - 70		JAN 15 2021
				QC 21 - SA - 53	UAS	

Part Op 100 - (Weld per dwg A/R S.S. rod Batch: M139024) Weld D3407-1/-5 using welding rod TIG174 as per Dwg D3407 & Descriptions: QSI 004 A/R TIG174 ROD Batch: M139024

110 - QC9- Inspect visual per QSI004 Fusion Welds

120 - (QC5- Inspect part completeness to step on W/O) M1235590

130 - (White Gloss/Ref:4.3.5.2) per QSI005 4.3-Steel) **Mask Threaded Section** START TIME: 11:05 OVEN

TEMPERATURE: 700 FINISH TIME: 11:05

140 - (QC3- Inspect Part Finish)

150 - (Identify as per dwg & Stock Location: _____)

160 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3407-1	Stem	16 pcs (1 ea)	100-Large Fab - Welded Assy-1	5222819
D3407-5	Ring	16 pcs (1 ea)	100-Large Fab - Welded Assy-1	5222504

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	D3407-1	16	0	0
	D3407-5	16	37	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Cross tube ☐ Eng. (Non-AW) ☐ Skid-tube ☐ Prod. Eng. Coord. ☐ Machining ☐ Rec/Store/Packaging ☐ Large Fab ☐ Finishing ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		MRB (QS1042) ☐									
Date: _____		Sequence #: _____		QTY Affected: _____		Disposition									
Description Work Order Deviation				Completed By											
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				Lead hand / Supervisor											
				QC / QA Coordinator											
				Fault Category											
Pressure/Forced Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____				Contamination Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐				Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			